



(19)

Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

**EP 0 864 726 A2**

(12)

**EUROPEAN PATENT APPLICATION**

(43) Date of publication:

**16.09.1998 Bulletin 1998/38**

(51) Int Cl.<sup>6</sup>: **E21B 43/26**

(21) Application number: **98301840.9**

(22) Date of filing: **12.03.1998**

(84) Designated Contracting States:

**AT BE CH DE DK ES FI FR GB GR IE IT LI LU MC  
NL PT SE**

Designated Extension States:

**AL LT LV MK RO SI**

(30) Priority: **13.03.1997 US 816665**

(71) Applicant: **Halliburton Energy Services, Inc.**  
**Duncan, Oklahoma 73536 (US)**

(72) Inventors:

- **Nguyen, Phillip D.**  
**Duncan, Oklahoma 73533 (US)**

- **Brumley, John R.**  
**Duncan, Oklahoma 73533 (US)**
- **Norman, Lewis R.**  
**Duncan, Oklahoma 73533 (US)**

(74) Representative: **Wain, Christopher Paul et al**  
**A.A. THORNTON & CO.**  
**Northumberland House**  
**303-306 High Holborn**  
**London WC1V 7LE (GB)**

(54) **Stimulating wells in unconsolidated formations**

(57) Fluid production from an unconsolidated formation penetrated by a wellbore is stimulated whilst restricting the migration of formation sands with fluids produced from the formation, by injecting a hardenable resin composition into a portion of the formation surrounding the wellbore whereby that portion is consolidated into a hard permeable mass, forming an indentation in the

wellbore to facilitate the initiation of a fracture in the consolidated portion of the formation, creating a fracture in the formation extending from the wellbore through the consolidated portion of the formation into an unconsolidated portion thereof and depositing hardenable resin composition coated proppant in the fracture whereby the proppant is consolidated into a hard permeable mass.

## Description

The present invention relates generally to a method of stimulating wells in unconsolidated formations, and more particularly to a method of stimulating fluid production from such a well while restricting the migration of sand with the fluids produced therefrom.

Oil and gas wells are often completed in unconsolidated formations containing loose and incompetent sands which migrate with oil, gas and/or water produced by the wells. The presence of sand in the produced fluids is disadvantageous and undesirable in that the sand particles abrade pumping and other producing equipment and reduce the fluid production capabilities of the producing zones in the wells.

Incompetent subterranean formations include those which contain loose sands that are readily entrained by produced fluids and those wherein the sand particles making up the formations are bonded together with insufficient bond strength to withstand the forces produced by the production of fluids from the formations. A technique which is often used for minimizing sand production from such formations has been to produce fluids from the formations at low flow rates whereby the near well stabilities of sand bridges and the like in the formations are preserved. However, the collapse of such sand bridges often occurs as a result of unintentional high production rates and pressure surging.

Heretofore, unconsolidated formations have been treated by creating fractures in the formations and depositing proppant in the fractures to maintain them in open positions. In addition, the proppant has heretofore been consolidated within the fractures into hard permeable masses by hardenable resin compositions to reduce the migration of sand through the fractures with produced fluids. Very often, to insure that sand is not produced, costly gravel packs, sand screens and the like have also been installed in the wells. Since gravel packs, sand screens and the like filter out the sand from the fluids being produced, the presence of the filtered sand adds to the flow resistance thereby producing additional pressure drawdown which causes the fracture faces and other portions of the unconsolidated formations to break down and the consolidated proppant in fractures, gravel packs and the like to be bypassed.

In wells formed in shallow, high permeability unconsolidated producing formations, creating fractures which extend significant distances into the formations is difficult to accomplish. The reason for this is that the horizontal stresses around the wellbore in an unconsolidated formation are generally the same, and instead of a single fracture which extends from opposing sides of the wellbore, i.e., a bi-wing fracture, multiple fractures are formed around the wellbore. Such multiple fractures accept fluids and proppant, but they often can not be extended to the optimum length required for a successful stimulation procedure. In addition, the conductivities of the multiple fractures are much lower than the conduc-

tivity of a single bi-wing fracture.

Thus, there is a need for improved methods of stimulating wells formed in unconsolidated hydrocarbon producing formations whereby bi-wing fractures can be formed extending to optimum lengths in the formations to thereby increase fluid production from the formations while preventing the migration of formation sand with the produced fluids so that gravel packs, sand screens and the like are not required.

We have now devised a method of stimulating such a well whereby the needs described above can be at least partly met.

According to the present invention, there is provided a method of stimulating fluid production from an unconsolidated formation penetrated by a wellbore while restricting the migration of formation sands with fluids produced from the formation, which method comprises the steps of:

- (a) injecting a hardenable resin composition into a portion of said formation surrounding said wellbore and causing said resin composition to harden whereby said portion of said formation is consolidated into a hard permeable mass;
- (b) forming at least one indentation in said wellbore which indentation extends into said consolidated portion of said formation to thereby facilitate the initiation of a fracture;
- (c) creating a fracture in said formation extending from said wellbore through said consolidated portion of said formation into an unconsolidated portion of said formation; and
- (d) depositing hardenable resin composition-coated proppant in said fracture and causing said resin composition to harden whereby said proppant is consolidated into a hard permeable mass which filters out and restricts the migration of formation sand with fluids produced through said fracture into said wellbore.

The method of the invention is particularly suitable for use in cased or open hole wells completed in unconsolidated formations. In the method, a hardenable resin composition is first injected into a portion of the unconsolidated formation surrounding the wellbore and caused to harden whereby that portion of the formation is consolidated into a hard permeable mass. A fracture, preferably a single bi-wing fracture, is next created in the formation extending from the wellbore through the consolidated portion of the formation into an unconsolidated portion of the formation. Thereafter, a hardenable resin composition coated proppant is deposited in the fracture and the resin composition is caused to harden whereby the proppant is consolidated into a hard permeable mass which filters out and restricts the migration of formation sands with fluids produced through the fracture into the wellbore.

In order to facilitate the initiation of a single bi-wing

fracture extending through the consolidated portion and into unconsolidated portions of the formation, at least one indentation, and preferably a pair of opposed indentations, is formed in the wellbore, the indentation(s) extending into the consolidated portion of the formation. The or each indentation weakens the consolidated portion of the formation whereby a single bi-wing fracture is created therein extending into unconsolidated portions of the formation. The term "bi-wing fracture" is used herein to mean a fracture which extends outwardly from a wellbore on opposite sides thereof in a plane which is generally parallel to the axis of the wellbore.

The combination of the consolidated portion of the formation around the wellbore through which the fracture extends and the consolidated proppant in the fracture restricts the migration of sand with produced fluids from the formation. This can eliminate the necessity of installing expensive gravel packs, sand screens and the like.

The above mentioned indentations can be holes, slots or the like which extend into the consolidated portion of the formation from the wellbore. The combination of the consolidation of the portion of the incompetent formation through which the fracture is formed and the indentations formed therein cause a single bi-wing fracture to be created instead of multiple, narrow and short fractures which would otherwise result. A variety of techniques can be utilized to form the indentations which are well known to those skilled in the art. Preferred such techniques include forming opposing holes extending from the open hole wellbore into the consolidated portion of the formation utilizing a conventional perforating gun or forming opposing slots in the consolidated formation utilizing a cutting tool such as a fluid jet cutting tool.

The hardenable resin compositions which are useful in accordance with the present invention for consolidating a portion of the formation as well as the proppant deposited in the bi-wing fracture formed are generally comprised of a hardenable organic resin and a resin-to-sand coupling agent. Such resin compositions are well known to those skilled in the art as are their use for consolidating portions of unconsolidated formations and fracture proppant material into hard permeable masses. A number of such compositions are described in detail in U.S. Patent No. 4,042,032 issued to Anderson et al. on August 16, 1977, U.S. Patent No. 4,070,865 issued to McLaughlin on January 31, 1978, U.S. Patent No. 5,058,676 issued to Fitzpatrick et al. on October 22, 1991 and U.S. Patent No. 5,128,390 issued to Murphey et al. on July 7, 1992, all of which are incorporated herein by reference. The hardenable organic resin used is preferably a liquid at 80°F and is cured or hardened by heating or by contact with a hardening agent.

Examples of hardenable organic resins which are particularly suitable for use in accordance with this invention are novolak resins, polyepoxide resins, polyester resins, phenol-aldehyde resins, urea-aldehyde res-

ins, furan resins and urethane resins. These resins are available at various viscosities, depending upon the molecular weight of the resin.

The preferred viscosity of the organic resin used in accordance with this invention is in the range of from about 1 to about 1,000 centipoises at 80°F. However, as will be understood, resins of higher viscosities can be utilized when mixed or blended with one or more diluents. Examples of suitable diluents for polyepoxide resins are styrene oxide, octylene oxide, furfuryl alcohol, phenols, furfural, liquid monoepoxides such as allyl glycidyl ether, and liquid diepoxides such as diglycidyl ether or resorcinol. Examples of such diluents for furfuryl alcohol resins, phenol-aldehyde resins and urea-aldehyde resins include, but are not limited to, furfuryl alcohol, furfural, phenol and cresol. Diluents which are generally useful with all of the various resins mentioned above include phenols, formaldehydes, furfuryl alcohol and furfural.

The resin-to-sand coupling agent is utilized in the hardenable resin compositions to promote coupling or adhesion to sand and other silicious materials in the formation to be treated. A particularly suitable such coupling agent is an aminosilane compound or a mixture of aminosilane compounds selected from the group consisting of N-β-(aminoethyl)-γ-aminopropyltrimethoxysilane, N-β-(aminoethyl)-N-β-(aminoethyl)-γ-aminopropyltrimethoxysilane, N-β-(aminopropyl)-N-β-(aminobutyl)-γ-aminopropyltriethoxysilane and N-β-(aminopropyl)-γ-aminopropyltriethoxysilane. The most preferred coupling agent is N-β-(aminoethyl)-γ-aminopropyltrimethoxysilane.

As mentioned, the hardenable resin composition used is caused to harden by heating in the formation or by contact with a hardening agent. When a hardening agent is utilized, it can be included in the resin composition (internal hardening agents) or the resin composition can be contacted with the hardening agent after the resin composition has been placed in the subterranean formation to be consolidated (external hardening agents). An internal hardening agent is selected for use that causes the resin composition to harden after a period of time sufficient for the resin composition to be placed in a subterranean zone or formation. Retarders or accelerators to lengthen or shorten the cure times are also utilized. When an external hardening agent is used, the hardenable resin composition is first placed in a zone or formation to be consolidated followed by an overflush solution containing the external hardening agent.

Suitable internal hardening agents for hardening resin compositions containing polyepoxide resins include, but are not limited to, amines, polyamines, amides and polyamides. A more preferred internal hardening agent for polyepoxide resins is a liquid eutectic mixture of amines and methylene dianiline diluted with methyl alcohol. Examples of internal hardening agents which can be used with resin compositions containing

furan resins, phenol-aldehyde resins, urea-aldehyde resins and the like are hexachloroacetone, 1,1,3-trichlorotrifluoroacetone, benzotrichloride, benzylchloride and benzalchloride.

Examples of external hardening agents for consolidating furan resins, phenol-aldehyde resins and urea-aldehyde resins are acylhalide compounds, benzotrichloride, acetic acid, formic acid and inorganic acids such as hydrochloric acid. Generally, external hardening agents selected from the group consisting of inorganic acids, organic acids and acid producing chemicals are preferred. The hardenable resin compositions can also include surfactants, dispersants and other additives well known to those skilled in the art.

The creation of fractures in a subterranean formation utilizing a hydraulic fracturing process is also well known to those skilled in the art. The hydraulic fracturing process generally involves pumping a viscous fracturing fluid containing suspended particulate proppant into the formation at a rate and pressure whereby fractures are created therein. The continued pumping of the fracturing fluid extends the fractures in the formation and carries proppant into the fractures. Upon the reduction of the flow of the fracturing fluid and the reduction in pressure exerted on the formation, the proppant is deposited in the fractures and the fractures are prevented from closing by the presence of the proppant therein.

Typical fracturing fluids which have been utilized heretofore include gelled water or oil base liquids, foams and emulsions. The foams utilized have generally been comprised of water based liquids containing one or more foaming agents foamed with a gas such as nitrogen. Emulsions formed with two or more immiscible liquids have also been utilized. A particularly useful emulsion for carrying out formation fracturing procedures is comprised of a water based liquid and a liquified, normally gaseous fluid such as carbon dioxide. Upon pressure release, the liquified gaseous fluid vaporizes and rapidly flows out of the formation.

The most common fracturing fluid utilized heretofore has been comprised of an aqueous liquid such as fresh water or salt water combined with a gelling agent for increasing the viscosity of the fluid. The increased viscosity reduces fluid loss and allows the fracturing fluid to transport significant concentrations of proppant into the created fractures.

A variety of gelling agents have been utilized including hydratable polymers which contain one or more of the functional groups such as hydroxyl, cis-hydroxyl, carboxyl, sulfate, sulfonate, amino or amide. Particularly useful such polymers are polysaccharide and derivatives thereof which contain one or more of the monosaccharide units galactose, mannose, glucoside, glucose, xylose, arabinose, fructose, glucuronic acid or pyranosyl sulfate. Natural hydratable polymers containing the foregoing functional groups and units include guar gum and derivatives thereof, locust bean gum, tara, konjak, tamarind, starch, cellulose and derivatives thereof, ka-

raya, xanthan, tragacanth and carrageenan. Hydratable synthetic polymers and copolymers which contain the above mentioned functional groups and which have been utilized heretofore include polyacrylate, polymethacrylate, polyacrylamide, maleic anhydride, methylvinyl ether polymers, polyvinyl alcohol and polyvinylpyrrolidone.

Preferred hydratable polymers which yield high viscosities upon hydration, i.e., apparent viscosities in the range of from about 10 centipoises to about 90 centipoises at concentrations in the range of from about 10 pounds per 1,000 gallons to about 80 pounds per 1,000 gallons in water, are guar gum and guar derivatives such as hydroxypropylguar and carboxymethylguar, cellulose derivatives such as hydroxyethyl cellulose, carboxymethyl cellulose and carboxymethylhydroxyethyl cellulose, locust bean gum, carrageenan gum and xanthan gum.

The viscosities of aqueous polymer solutions of the types described above can be increased by combining crosslinking agents with the polymer solutions. Examples of crosslinking agents which can be utilized are multivalent metal salts or compounds which are capable of releasing the metal ions in an aqueous solution. Examples of such multivalent metal ions are chromium, zirconium, antimony, titanium, iron (ferrous or ferric), zinc or aluminum.

The above described gelled or gelled and crosslinked fracturing fluids can also include gel breakers such as those of the enzyme type, the oxidizing type or the acid buffer type which are well known to those skilled in the art. The gel breakers cause the viscous fracturing fluid to revert to thin fluids that can be produced back to the surface after they have been used to create fractures and carry proppant in a subterranean formation.

Particulate proppant material is suspended in the viscous fracturing fluid so that it is carried into the created fractures and deposited therein by the fracturing fluid when the flow rate of the fracturing fluid and the pressure exerted on the fractured subterranean formation are reduced. The proppant functions to prevent the fractures from closing due to overburdened pressures, i.e., to prop the fractures open, whereby produced fluids can flow through the fractures. Also, the proppant is of a size such that formation sands migrating with produced fluids are prevented from flowing through the flow channels formed by the fractures, i.e., the proppant filters out the migrating sand. Various kinds of particulate materials can be utilized as proppant in accordance with the present invention including sand, bauxite, ceramic materials, glass materials and "TEFLON™" materials. The particulate material used can have a particle size in the range of from about 2 to about 400 mesh, U.S. Sieve Series. The preferred particulate material is sand having a particle size in the range of from about 10 to about 70 mesh, U.S. Sieve Series. Preferred sand particle size distribution ranges are 1 or more of 10-20 mesh, 20-40 mesh, 40-60 mesh or 50-70 mesh, de-

pending on the particle size and distribution of the formation sand to be screened out by the proppant.

The proppant size and distribution are carefully selected in accordance with the size and distribution of the formation sand and the proppant is coated with a hardenable resin composition of the type described above. The resin coated proppant can be prepared in accordance with conventional batch mixing techniques followed by the suspension of the resin coated proppant in the fracturing fluid utilized. Alternatively, the fracturing fluid containing resin coated proppant can be prepared in a substantially continuous manner such as in accordance with the methods disclosed in U.S. Patent No. 4,829,100 issued on May 9, 1989 to Murphey et al. or U.S. Patent No. 5,128,390 issued on July 7, 1992 to Murphey et al., both of which are incorporated herein by reference.

A preferred method of the present invention for stimulating fluid production from an unconsolidated formation penetrated by a wellbore while preventing the migration of formation sands with fluids produced from the formation is comprised of the following steps. A hardenable resin composition is injected into a portion of the formation adjacent to and surrounding the wellbore and the resin composition is caused to harden whereby that portion of the formation is consolidated into a hard permeable mass. A pair of opposing indentations are formed in the wellbore which extend into the consolidated portion of the formation to facilitate the initiation of a by-wing fracture. A bi-wing fracture is next created in the formation extending from the wellbore through the consolidated portion of the formation into unconsolidated portions thereof. A hardenable resin composition coated proppant is deposited in the fracture and the resin composition is caused to harden whereby the proppant is consolidated into a hard permeable mass which filters out and prevents the migration of formation sands with fluids produced from the fracture into the wellbore.

When the unconsolidated producing formation or zone has a height of about 100 feet or less, a minimum of 5 to 10 feet of the formation must be consolidated, fractured and packed with consolidated proppant. Generally, the ratio of the total height of the producing formation or zone to the height of the consolidated and fractured portion of the formation or zone is about 10. When the producing zone height is greater than about 100 feet, multiple fractured consolidations can be utilized.

The consolidated portion of the producing formation or zone surrounding the wellbore formed in accordance with this invention is generally ring-shaped having a minimum vertical thickness of about 5 feet and a diameter in the range of from about 1 to about 8 feet. As mentioned, the bi-wing fracture formed extends from opposite sides of the wellbore through the ring-shaped consolidated portion and outwardly into the unconsolidated formation to an optimum distance based on the overall

size of the producing formation or zone and other factors.

## 5 Claims

1. A method of stimulating fluid production from an unconsolidated formation penetrated by a wellbore while restricting the migration of formation sands with fluids produced from the formation, which method comprises the steps of:

(a) injecting a hardenable resin composition into a portion of said formation surrounding said wellbore and causing said resin composition to harden whereby said portion of said formation is consolidated into a hard permeable mass;  
 (b) forming at least one indentation in said wellbore which indentation extends into said consolidated portion of said formation to thereby facilitate the initiation of a fracture;  
 (c) creating a fracture in said formation extending from said wellbore through said consolidated portion of said formation into an unconsolidated portion of said formation; and  
 (d) depositing hardenable resin composition-coated proppant in said fracture and causing said resin composition to harden whereby said proppant is consolidated into a hard permeable mass which filters out and restricts the migration of formation sand with fluids produced through said fracture into said wellbore.

2. A method according to claim 1, wherein said indentation formed in said wellbore comprises a hole formed by a perforating gun.
3. A method according to claim 1 or 2, wherein said indentation formed in said wellbore is comprised of a slot formed by a fluid jet cutting tool.
4. A method according to claim 1, 2 or 3, wherein said hardenable resin composition comprises an organic resin selected from novolak resins, polyepoxide resin, polyester resins, phenol-aldehyde resins, urea-aldehyde resins, furan resins and urethane resins.
5. A method according to claim 4, wherein said hardenable resin composition is caused to harden by being heated in said formation.
6. A method according to claim 4, wherein said hardenable resin composition further comprises an internal hardening agent which causes said resin to harden after being injected or deposited in said formation.

7. A method according to claim 6, wherein said hardenable resin composition is a polyepoxide resin and said internal hardening agent is a liquid eutectic mixture of amines and methylene dianiline diluted with methyl alcohol. 5
8. A method according to claim 4, which further comprises the step of contacting said hardenable resin composition with an external hardening agent after said hardenable resin composition has been injected or deposited in said formation thereby causing said resin composition to harden. 10
9. A method according to claim 8, wherein said hardenable resin composition is a furan resin and said external hardening agent is hydrochloric acid. 15
10. A method according to any of claims 1 to 9, wherein said fracture is created in accordance with step (c) by pumping a fracturing fluid into said formation at a sufficient rate and pressure to fracture said formation. 20

25

30

35

40

45

50

55



(19)

Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

**EP 0 864 726 A3**

(12)

**EUROPEAN PATENT APPLICATION**

(88) Date of publication A3:

**10.03.1999 Bulletin 1999/10**

(51) Int Cl.<sup>6</sup>: **E21B 43/26**

(43) Date of publication A2:

**16.09.1998 Bulletin 1998/38**

(21) Application number: **98301840.9**

(22) Date of filing: **12.03.1998**

(84) Designated Contracting States:

**AT BE CH DE DK ES FI FR GB GR IE IT LI LU MC  
NL PT SE**

Designated Extension States:

**AL LT LV MK RO SI**

• **Brumley, John R.**

**Duncan, Oklahoma 73533 (US)**

• **Norman, Lewis R.**

**Duncan, Oklahoma 73533 (US)**

(30) Priority: **13.03.1997 US 816665**

(71) Applicant: **Halliburton Energy Services, Inc.**  
**Duncan, Oklahoma 73536 (US)**

(74) Representative: **Wain, Christopher Paul et al**

**A.A. THORNTON & CO.**

**Northumberland House**

**303-306 High Holborn**

**London WC1V 7LE (GB)**

(72) Inventors:

• **Nguyen, Phillip D.**

**Duncan, Oklahoma 73533 (US)**

(54) **Stimulating wells in unconsolidated formations**

(57) Fluid production from an unconsolidated formation penetrated by a wellbore is stimulated whilst restricting the migration of formation sands with fluids produced from the formation, by injecting a hardenable resin composition into a portion of the formation surrounding the wellbore whereby that portion is consolidated into a hard permeable mass, forming an indentation in the

wellbore to facilitate the initiation of a fracture in the consolidated portion of the formation, creating a fracture in the formation extending from the wellbore through the consolidated portion of the formation into an unconsolidated portion thereof and depositing hardenable resin composition coated proppant in the fracture whereby the proppant is consolidated into a hard permeable mass.



European Patent  
Office

# EUROPEAN SEARCH REPORT

Application Number  
EP 98 30 1840

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
X	EP 0 476 820 A (MOBIL OIL CORP) 25 March 1992 * column 1, line 35 - line 50 *	1	E21B43/26 E21B43/02
Y	---	2-10	
Y	US 5 293 939 A (SURLES BILLY W ET AL) 15 March 1994 * column 6, line 52 - line 56 * * column 7, line 56 - line 59 * * column 8, line 59 - column 9, line 1 *	4,5,8,9	
Y	US 4 074 760 A (COPELAND CLAUDE T ET AL) 21 February 1978 * column 2, line 28 - line 62 * * column 3, line 13 - line 20 * * column 4, line 15 - line 19 * * column 4, line 48 - line 64 * * column 5, line 40 - line 41 *	4,6,7	
Y	US 5 429 191 A (SCHMIDT JOSEPH H ET AL) 4 July 1995 * column 2, line 19 - line 22 * * column 4, line 23 - line 25 * * column 5, line 26 - line 32 *	2,10	TECHNICAL FIELDS SEARCHED (Int.Cl.6)  E21B
Y	US 5 445 220 A (GUREVICH ALEXANDER E ET AL) 29 August 1995 * column 1, line 60 - column 2, line 2 *	3	
A	US 5 604 184 A (ELLIS PATRICK D ET AL) 18 February 1997 * column 3, line 53 - line 60 * * column 7, line 1 - line 21 *	1,4	
D,A	US 5 128 390 A (MURPHEY JOSEPH R ET AL) 7 July 1992 * column 2, line 56 - column 3, line 13 * * column 5, line 35 - line 46 *	4,6,7	
---			
-/--			
The present search report has been drawn up for all claims			
Place of search <b>THE HAGUE</b>		Date of completion of the search <b>20 January 1999</b>	Examiner <b>Garrido Garcia, M</b>
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	





European Patent  
Office

# EUROPEAN SEARCH REPORT

Application Number

EP 98 30 1840

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
A	US 5 178 218 A (DEES JOHN M) 12 January 1993 * column 7, line 36 - line 41 * * column 7, line 63 - column 8, line 4 * -----	4,8,9	
			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
The present search report has been drawn up for all claims			
Place of search <b>THE HAGUE</b>		Date of completion of the search <b>20 January 1999</b>	Examiner <b>Garrido Garcia, M</b>
<p><b>CATEGORY OF CITED DOCUMENTS</b></p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons</p> <p>Δ : member of the same patent family, corresponding document</p>			

**ANNEX TO THE EUROPEAN SEARCH REPORT  
ON EUROPEAN PATENT APPLICATION NO.**

EP 98 30 1840

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on  
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

20-01-1999

Patent document cited in search report		Publication date	Patent family member(s)		Publication date
EP 0476820	A	25-03-1992	CA	2049193 A	21-03-1992
US 5293939	A	15-03-1994	NONE		
US 4074760	A	21-02-1978	CA	1077701 A	20-05-1980
			US	4101474 A	18-07-1978
US 5429191	A	04-07-1995	NONE		
US 5445220	A	29-08-1995	NONE		
US 5604184	A	18-02-1997	WO	9812416 A	26-03-1998
			AU	6887796 A	14-04-1998
US 5128390	A	07-07-1992	NONE		
US 5178218	A	12-01-1993	CA	2071266 A	20-12-1992
			GB	2256886 A,B	23-12-1992